

Work Order ID 62430

September 30, 2010 8:00:02 AM



Page 1

Item ID: D4172-043

Accept



Setup Start



Revision ID:

Item Name: Z-Shape Section Assembly, LH

Stop



Start Date: 9/30/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/15/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: CL Date: 10/9/30 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4172	A								

100

0.00



Small Fab

Memo

0.00

Small Fab

1- Transfer drill holes, deburr and assemble as per dwg

25 10-10-13 (X)

110

QC5- Inspect part completeness to step on W/O

0.00



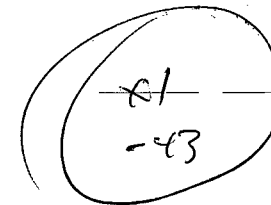
QC

Memo

0.00

Quality Control

8 10/10/13



Pto →

120

Identify as per dwg & Stock Location: composites

0.00



Packaging

Memo

0.00

Packaging

25 10-10-13 (X)

W/O: 62430		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10-12	100	Back of clearance along inside edge of D4172-3 angle (nut plate in the way). install rivet CR 3213-4-04 from opposite side 1 location	RT	10-10-12	1	10.10.13	S 10/10/13

Part No: D4172-043 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62430

September 30, 2010 8:00:02 AM



Page 2

Item ID: D4172-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Z-Shape Section Assembly, LH

Start Date: 9/30/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/15/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/18 *[Signature]*
mf
10-10-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

September 30, 2010 8:00:01 AM

Parent Item: D4172-043











Parent Item Name: Z-Shape Section Assembly, LH

Start Date: 9/30/10**Required Date:** 10/15/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.09.09 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4172-1 		Manufactured	No			100	Each	0.0000	1	1			
Supporting Plate						B61938	x1				RT	10-10-07	
D4172-4 	D4172-5	Manufactured	No			100	Each	0.0000	1	1			
Support Angle						062429	x1				RT	10-10-07	
D4172-6 	D4172-3	Manufactured	No			100	Each	0.0000	1	1			
Support Angle						B62427B62846	x1				RT	10-10-07	
CR3213-4-04 		Purchased	No			100	Each	200.0000	46	46			
Rivet						B 104291	x46				RT	10-10-07	
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
ST312						200							
115742						200							
MS20426AD34-5 		Purchased	No			100	Each	6,356.000	22	22			
RIVET						M 4179	x22				RT	10-10-07	
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
ST316						6356							
404374						2356							
110398						4000							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 2

September 30, 2010 8:00:01 AM

Work Order ID: 62430



Parent Item: D4172-043



Parent Item Name: Z-Shape Section Assembly, LH

Start Date: 9/30/10

Required Date: 10/15/10

Start Qty: 1.00

Required Qty: 1.00

MS21075L4

10.10.07

Purchased

No

100

Each

23.0000

11

11



Nutplate

m115837 x 11



10-10-07

Location

Loc Qty

Loc Code

ST303

23

115708

23

September 30, 2010 8:00:01 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

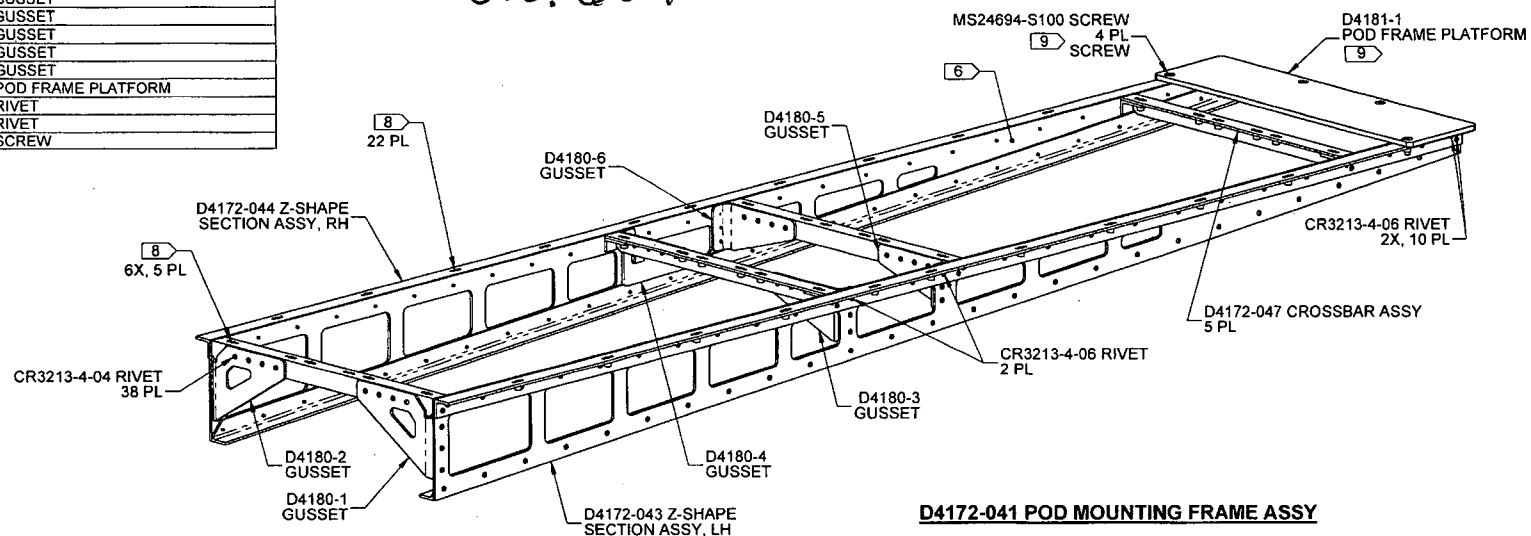
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

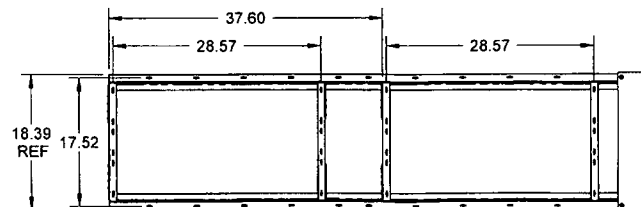
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4172-041	POD MOUNTING FRAME
1	1	D4172-043	Z-SHAPE SECTION ASSY, LH
2	1	D4172-044	Z-SHAPE SECTION ASSY, RH
3	5	D4172-047	CROSSBAR ASSY
4	1	D4180-1	GUSSET
5	1	D4180-2	GUSSET
6	1	D4180-3	GUSSET
7	1	D4180-4	GUSSET
8	1	D4180-5	GUSSET
9	1	D4180-6	GUSSET
10	1	D4181-1	POD FRAME PLATFORM
11	38	CR3213-4-04	RIVET
12	24	CR3213-4-06	RIVET
13	4	MS24694-S100	SCREW



D4172-041 POD MOUNTING FRAME ASSY



SUPPLEMENTAL VIEWS

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1 (PERMANENT INK MARKER)
- 7) WEIGHT: 15.0 lbs
- 8) MASK PRIOR TO POWDER COATING
- 9) INSTALL AFTER POWDER COATING

RELEASED
2010-09-29

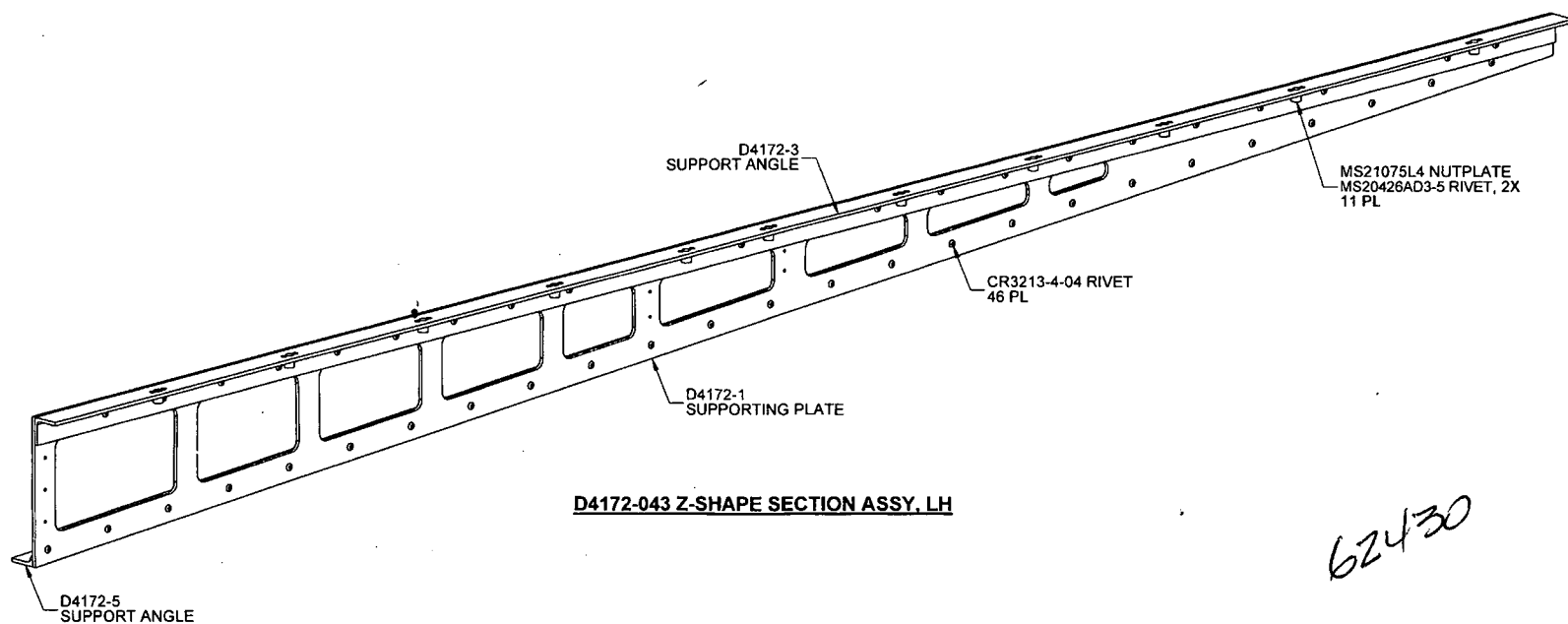
REV.	NEW ISSUE	DESCRIPTION	MB	10.09.15
DESIGN			BY	DATE
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	10.09.15			

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4172** REV. A
TITLE **POD MOUNTING FRAME ASSY** SCALE NTS
SHEET 1 OF 7

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ITEM	QTY -043	P/N	DESCRIPTION
	X	D4172-043	Z-SHAPE SECTION ASSY, LH
1	1	D4172-1	SUPPORTING PLATE
2	1	D4172-3	SUPPORT ANGLE
3	1	D4172-5	SUPPORT ANGLE
4	46	CR3213-4-04	RIVET
5	22	MS20426AD3-5	RIVET
6	11	MS21075L4	NUT PLATE



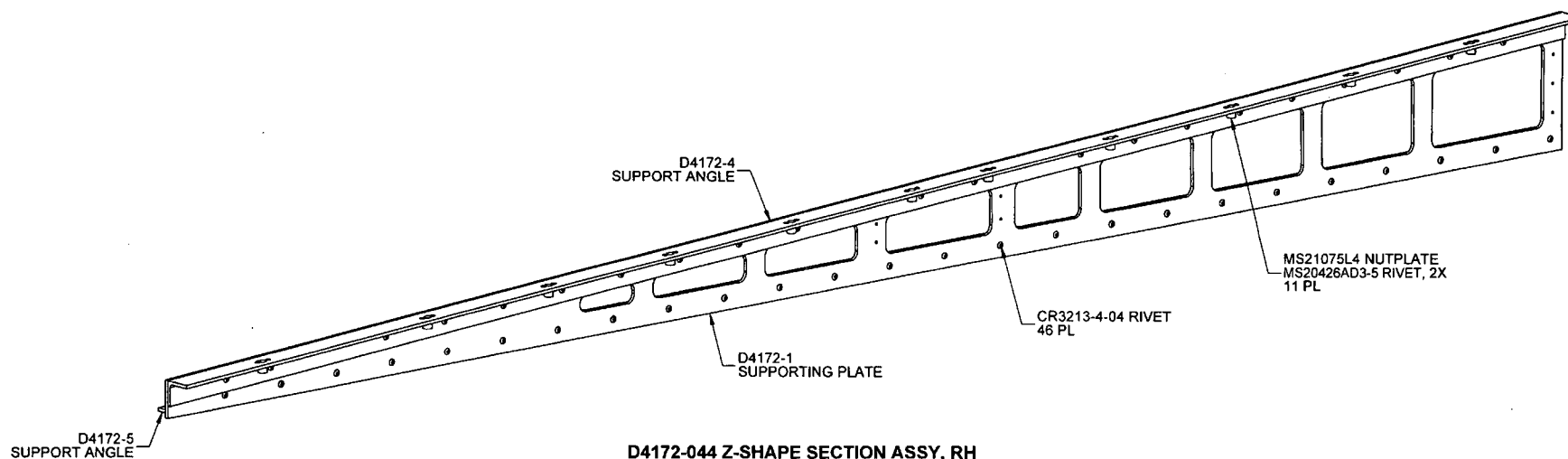
62430

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2010-09-29

- NOTES:
- 1) MATERIAL: NONE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 2.13 lbs

DESIGN	J	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	J	DRAWING NO.	REV. A
CHECKED	D	D4172	SHEET 2 OF 7
MFG. APPR.	D	TITLE	SCALE
APPROVED	D	POD MOUNTING FRAME ASSY	NTS
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DATE	10.09.15		

ITEM	QTY -044	P/N	DESCRIPTION
	X	D4172-044	Z-SHAPE SECTION ASSY, RH
1	1	D4172-1	SUPPORTING PLATE
2	1	D4172-4	SUPPORT ANGLE
3	1	D4172-5	SUPPORT ANGLE
4	46	CR3213-4-04	RIVET
5	22	MS20426AD3-5	RIVET
6	11	MS21075L4	NUT PLATE



D4172-044 Z-SHAPE SECTION ASSY, RH

NOTES:

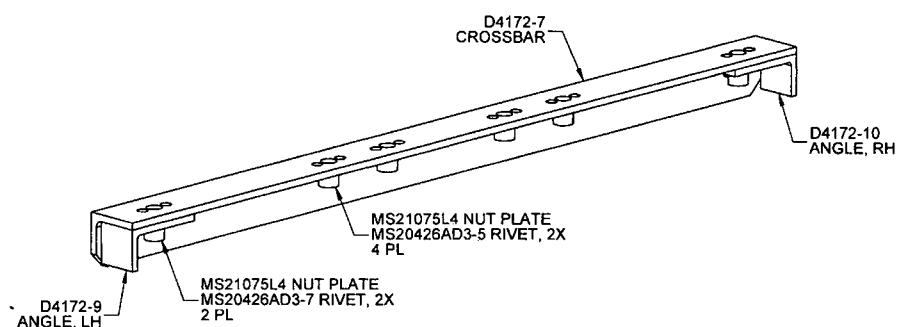
- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.14 lbs

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CHECKED	R	DRAWING NO.	REV. A
MFG. APPR.	R	D4172	SHEET 3 OF 7
APPROVED	R	TITLE	SCALE
DE APPR.	R	POD MOUNTING FRAME ASSY NTS	
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ITEM	QTY -047	P/N	DESCRIPTION
	X	D4172-047	CROSSBAR ASSY
1	1	D4172-7	CROSSBAR
2	1	D4172-9	ANGLE
3	1	D4172-10	ANGLE
4	6	MS21075L4	NUT PLATE
5	8	MS20426AD3-5	RIVET
6	4	MS20426AD3-7	RIVET



D4172-047 CROSSBAR ASSY

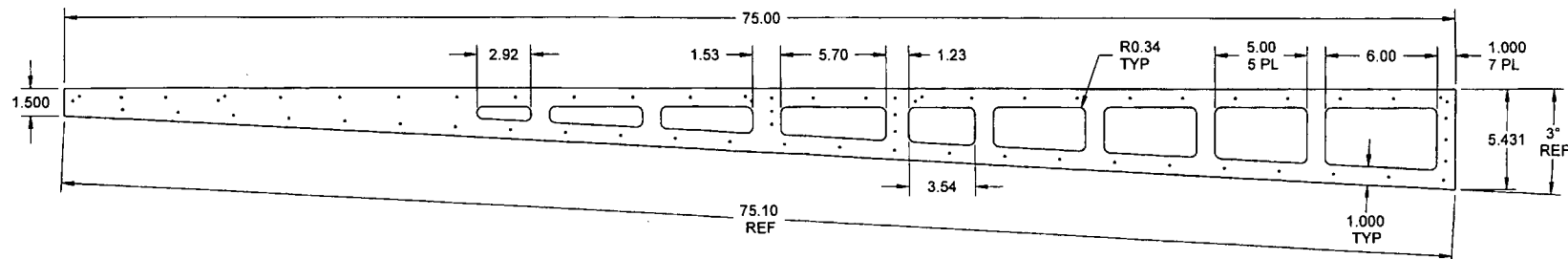
NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.18 lbs

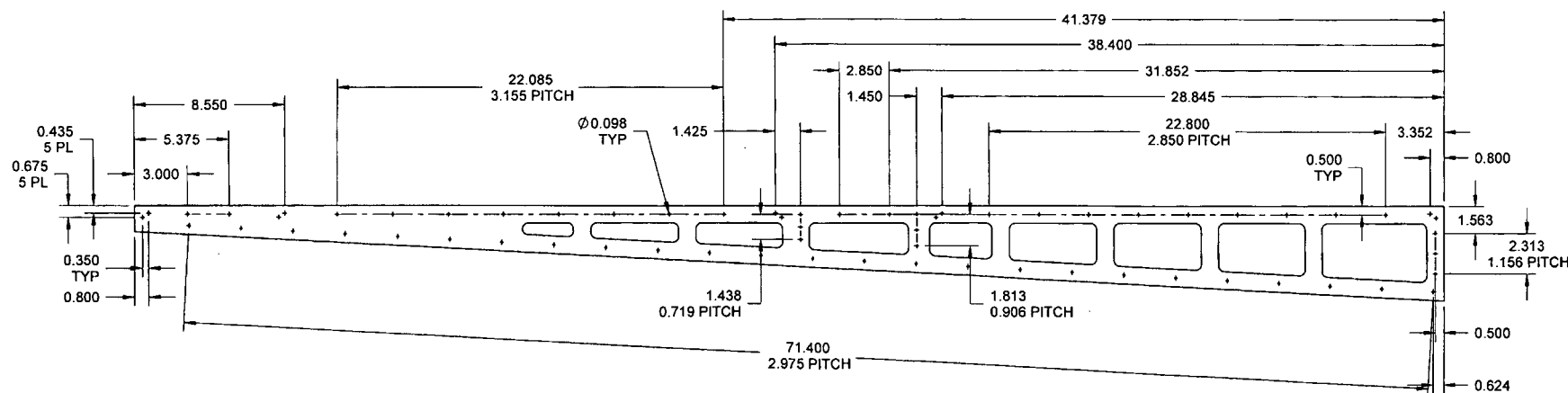
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DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4172	SHEET 4 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	POD MOUNTING FRAME ASSY	NTS
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8 7 6 5 4 3 2 1



D4172-1 SUPPORTING PLATE



SUPPLEMENTAL VIEW

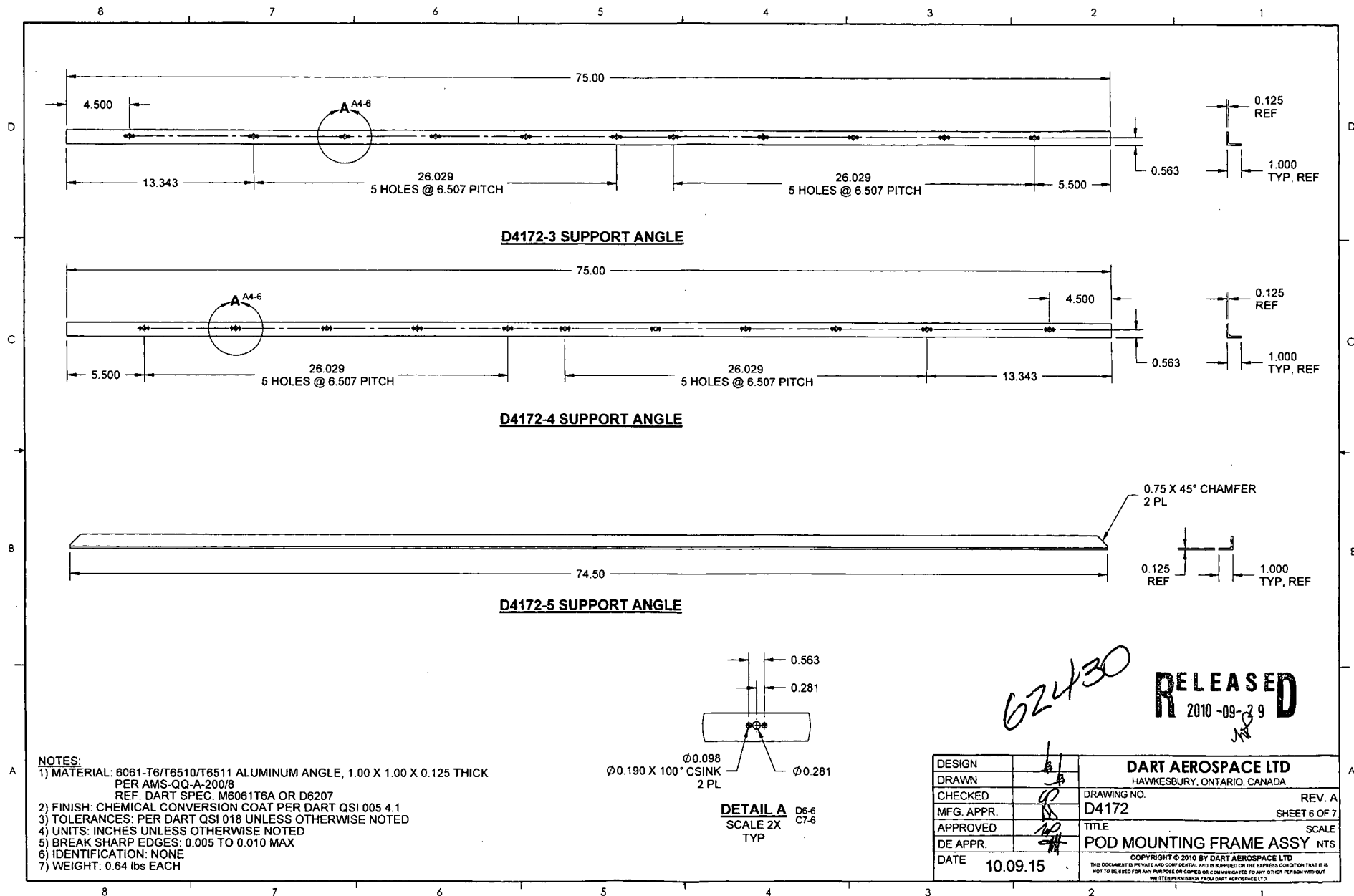
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2010-09-29

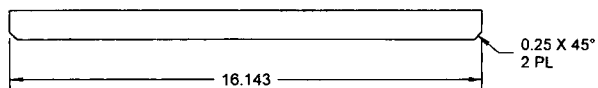
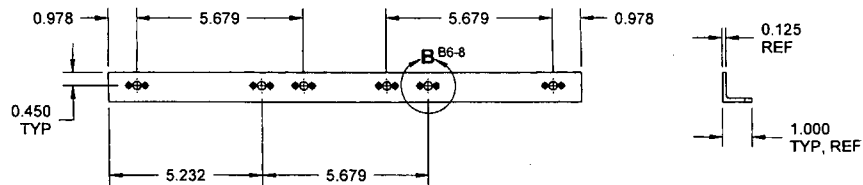
NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.125 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.78 lbs

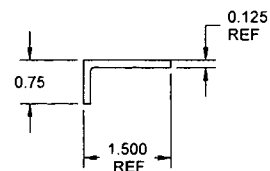
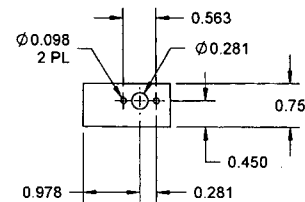
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4172	REV. A
MFG. APPR.			SHEET 5 OF 7
APPROVED		TITLE	SCALE
DE APPR.		POD MOUNTING FRAME ASSY	NTS
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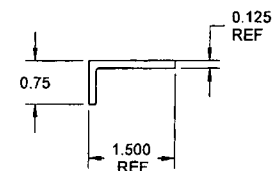
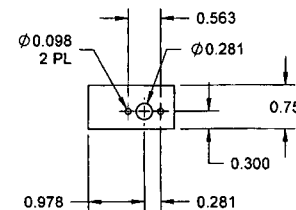
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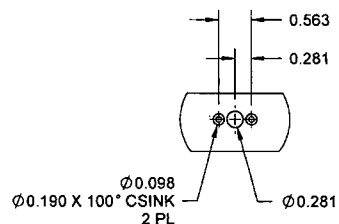
D4172-7 CROSSBAR



D4172-9 ANGLE



D4172-10 ANGLE



DETAIL B
D6-8
SCALE 2X
TYP

NOTES:

- 1) MATERIAL
D4172-7: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 1.00 X 1.00 X 0.125 THICK
PER AMS-QQ-A-200/8
REF. DART SPEC. M6061T6A OR D6207
D4172-9/-10: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 1.50 X 1.50 X 0.125 THICK
PER AMS-QQ-A-200/8
REF. DART SPEC. M6061T6A OR D6203
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D4172-7 = 0.14 lbs; D4172-9/-10 = 0.01 lbs EACH

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4172	SHEET 7 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	POD MOUNTING FRAME ASSY NTS	
DATE	10.09.15	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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2010-09-29

8 7 6 5 4 3 2 1